

Work Order ID 119768

119768

Page 1

May-22-14 10:25:19 AM

Item ID: D139-816-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/22/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-05-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9686	A
DSI9691	A
IIN-D139-816	D

JD

100	Document Control	0.00	
100	DOCUMENT CONTROL		
DC	Memo	0.00	
Doc.Control -USB or Paperwork	Photocopy blue file & type labels as per PPP D139-816-011 CHG005		

DAS
05
189

JUN 25 2014

MLJ 14-06-25

110	Pick Kit	0.00	
110			
Packaging	Memo	0.00	
Packaging			

17/5/14 JB DAS
31
9-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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119768

Page 2

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Item ID: D139-816-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/22/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

JUN 25 2014

DAS

06

9-89

JUN 24 2014

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Package as per PPP D139-816-011 Identify and Stock
Location: _____

JUN 24 2014

DAS

06

9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 140628

MF 14-6-25

DQA: _____ Date: _____



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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

May-22-14 10:25:22 AM

Page 2

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D4636-043
D4636-043
Receptacle Bracket Assembly

DAS
06
9-89

Manufactured No

110 Each

12.0000

16 16

**

117651

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST117

12

114598

12

Manufactured No

110 Each

15.0000

10 10

**

117652

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST116

15

114651

6

92961

9

Manufactured No

110 Each

79.0000

16 16

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

MF3

20

111978

18

113948

2

ST115

59

114660

11

116195

48

Manufactured No

110 Each

4.0000

4 4

**

116195
119838

DAS
32
9-89

14-06-06

Location

Loc Qty

Loc Code

ST116

4

114751

4

DAS
31
9-89

D4636-5
D4636-5
Bracket

DAS
06
9-89

Manufactured No

110 Each

4.0000

4 4

**

116195
119838

DAS
32
9-89

14-06-06

D4636-7
D4636-7
Retainer Plate

DAS
06
9-89

May-22-14 10:25:22 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

May-22-14 10:25:22 AM

Page 3

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D4636-9

Manufactured No

110

Each

20.0000

1

D4636-9

Template

DAS
06
9-89

Location

Loc Qty

Loc Code

ST115

2

111233

2

ST116

18

117653

18

**

DAS
33
9-89

DAS
31
9-89

D4648-1

Manufactured No

110

Each

2.0000

1

D4648-1

Template

DAS
06
9-89

Location

Loc Qty

Loc Code

ST133

2

113950

2

**

DAS
32
9-89

DAS
31
9-89

D4653-041

Manufactured No

110

Each

6.0000

6

D4653-041

Vent Manifold Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

6

119081

6

**

DAS
32
9-89

DAS
31
9-89

D4653-11

Manufactured No

110

Each

42.0000

6

D4653-11

Clamp

DAS
06
9-89

Location

Loc Qty

Loc Code

st113

36

117661

36

ST118

6

111998

6

**

DAS
33
9-89

14-06-04

DAS
31
9-89

May-22-14 10:25:22 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ 22	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

May-22-14 10:25:22 AM

Page 4

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D4664-7

Manufactured No

110

Each

75.0000

3 3

DAS

33

9-89

DAS

31

9-89

D4664-7

Spacer

DAS
06
9-89

Location

Loc Qty

Loc Code

ST118

75

107035

4

111835

31

114887

40

3x 111835 114887 114715

D4712-043

Manufactured No

110

Each

19.0000

2 2

DAS

33

9-89

DAS

31

9-89

D4712-043

Bracket Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

st113

17

114715

17

ST120

2

117572

2

114715

D4716-1

Manufactured No

110

Each

18.0000

2 2

DAS

33

9-89

14-06-04

D4716-1

Duct Hose

DAS
06
9-89

Location

Loc Qty

Loc Code

ST139

2

93111

2

ST139i

4

113888

4

ST146

12

114843

12

113888

DAS

31

9-89

May-22-14 10:25:23 AM

Shop Packet Print

Page 4

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 5

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D4716-3

Manufactured No

110

Each

32.0000

4 4

D4716-3

Duct Hose

DAS
06
9-89

Location

Loc Qty

Loc Code

st139g

8

113889

8

ST146

24

114844

24

**

DAS
33
9-89

DAS
31
9-89

D4716-5

Manufactured No

110

Each

54.0000

6 6

D4716-5

Duct Hose

DAS
06
9-89

Location

Loc Qty

Loc Code

ST139

12

111289

12

st139h

12

113890

12

ST146

30

114845

30

**

DAS
33
9-89

DAS
31
9-89

D4728-057

Manufactured No

110

Each

6.0000

1 1

D4728-057

Ps7J1 Jumper

DAS
06
9-89

Location

Loc Qty

Loc Code

MF5

6

111210

1

116306

5

**

DAS
33
9-89

DAS
31
9-89

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 6

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D4728-063

Manufactured No

110

Each

6.0000

1

D4728-063

Cabin Temp Sensor Jumper Assembly

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

MF5

6

111217

1

116313

5

116313

D4730-020-035

Manufactured No

110

Each

142.0000

24

D4730-020-035

Velcro Strip 2.0W/ X 3.5L

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST121

114

110415

18

114738

1

119193

95

ST122

28

111390

28

119193

D5032-1

Manufactured No

110

Each

39.0000

16

D5032-1

Doubler

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST129

1

111811

1

ST130

22

111976

15

114652

7

ST131

16

116583

16

119834

14-06-04

May-22-14 10:25:23 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 7

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

D5032-3
D5032-3

Doubler

Manufactured No

110 Each

28.0000

16 16

DAS

33

9-89

DAS

31

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST131

28

116584

28

2351-20-21-C3C

Purchased No

110 Each

526.0000

16 16

DAS

33

9-89

DAS

31

9-89

2351-20-21-C3C
STUD

DAS
06
9-89

Location

Loc Qty

Loc Code

ST396

526

M127922

72

M128068

454

128068

50-009-2

Purchased No

100 Each

574.0000

16 16

DAS

33

9-89

DAS

31

9-89

50-009-2
Grommet

DAS
06
9-89

Location

Loc Qty

Loc Code

MF5

30

m128022

30

ST378

544

122594

1

m128022

11

m128047

532

128047

AN970-3

Purchased No

110 Each

396.0000

10 10

DAS

33

9-89

DAS

31

9-89

AN970-3
Washers

AS
06
9-89

Location

Loc Qty

Loc Code

ST508

396

m127432

6

m128057

390

128057

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Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

May-22-14 10:25:23 AM

Page 8

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

BT1.5I-M

Purchased

No

110

Each

1,561.000

24

24

BT1.5I-M

Tie Wrap

DAS
06
9-89

Location

Loc Qty

Loc Code

ST283

561

123742

561

st507

1000

m128238

1000

**

DAS
33
9-89

DAS
31
9-89

123742

BT3LH-L

Purchased

No

110

Each

508.0000

12

12

BT3LH-L

Tie Wrap

DAS
06
9-89

Location

Loc Qty

Loc Code

ST282

8

m128019

8

st507

500

m128238

500

**

DAS
33
9-89

DAS
31
9-89

128238

MS21042L3

Purchased

No

110

Each

6,747.000

35

35

MS21042L3

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

111

108816

9

M127410

13

M127831

41

M128401

48

ST506

955

123900

955

ST509

5681

M128754

5681

**

DAS
33
9-89

4-06-04

DAS
31
9-89

128754

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Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 9

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

MS24694-S51

Purchased

No

110

Each

238.0000

36

36

DAS

33

9-89

MS24694-S51

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST303

238

m127432

1

m128401

9

m128635

228

MS27039-1-15

Purchased

No

110

Each

852.0000

21

21

DAS

33

9-89

MS27039-1-15

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST306

252

124326

252

ST506

600

m127916

600

NAS1149D0316J

Purchased

No

110

Each

1,033.000

5

5

DAS

33

9-89

NAS1149D0316J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

ST293

633

M127993

633

ST510a

400

M127956

400

May-22-14 10:25:24 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

May-22-14 10:25:24 AM

Page 10

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

5,132.000

34

34

DAS

33

9-89

DAS

31

9-89

NAS1149D0332J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294

431

m128606

431

ST510a

4701

m128612

4701

128612

NAS1149D0663J

Purchased

No

110

Each

2,033.000

6

6

DAS

33

9-89

DAS

31

9-89

NAS1149D0663J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294

7

123265

4

M126284

3

ST510a

2026

M126334

699

M127813

35

M127916

292

M128818

1000

127916

CB200

Purchased

No

110

Each

30.0000

3

3

DAS

33

9-89

14-06-04

CB200

Acrylic Adhesive, 3.5G

DAS
06
9-89

Location

Loc Qty

Loc Code

ST283

30

m128958

20

m129209

10

128958

DAS

31

9-89

May-22-14 10:25:24 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

May-22-14 10:25:24 AM

Page 11

Work Order ID: 119768

119768

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 5/22/14

Required Date: 5/22/14

Start Qty: 1.00

Required Qty: 1.00

CS125-1032-8AACR

Purchased

No

110

Each

28.0000

2

2

CS125-1032-8AACR

Stud

DAS
33
9-89

DAS
31
9-89

DAS
33
9-89

Location

Loc Qty

Loc Code

ST283

28

M127974

28

127974

D5078-1

Manufactured

No

110

Each

24.0000

1

1

D5078-1

Bracket

DAS
33
9-89

14-06-04

DAS
33
9-89

Location

Loc Qty

Loc Code

ST139B

24

115477

24

115477

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54
REF. FAA STC: SR03251NY
REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accomodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	ALTERNATE INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54
REF. FAA STC: SR03251NY
REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

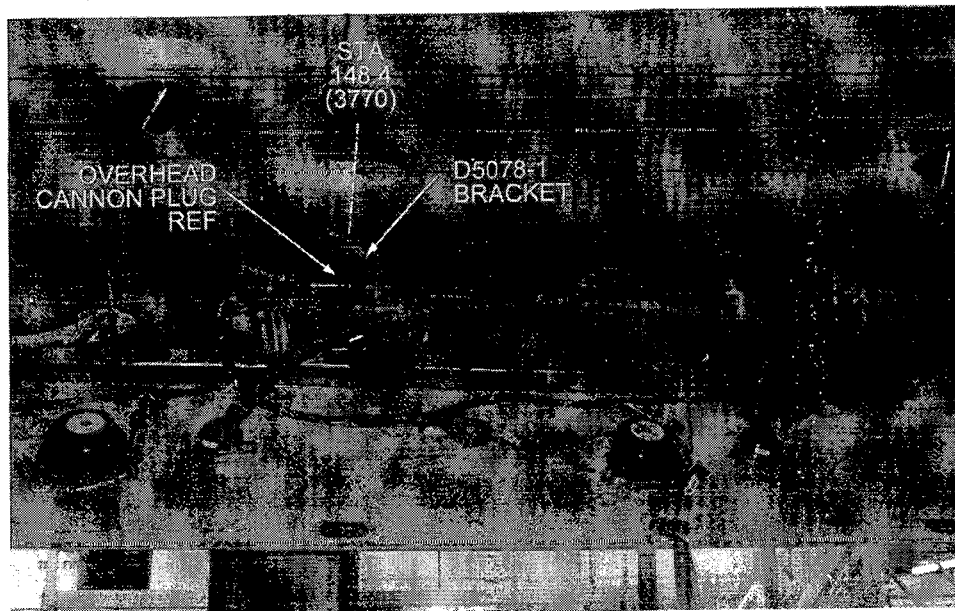


Figure 1. - LH Side Overhead Panel

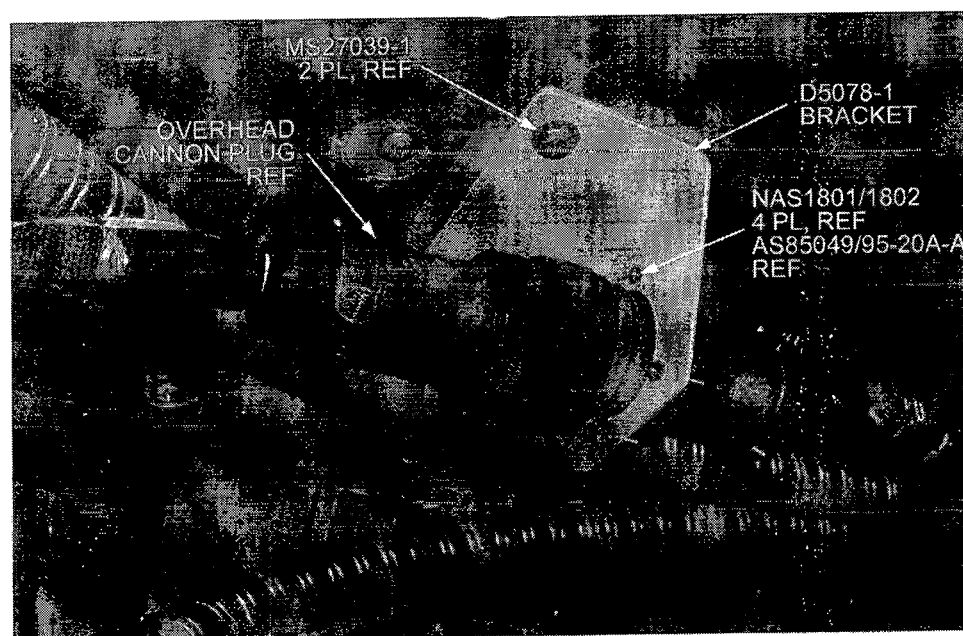


Figure 2. - D5078-1 Bracket Installation

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9691	REV. A
MFG. APPR.	N/A		SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE BRACKET INSTALLATION	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	14.03.24		

JUN 24 2014

DAS
06
9-89

5.0 PARTS LIST

REFERENCE ONLY

Qty -011	Part Number	Description
X	D139-816-011	INTERIOR CEILING PANEL KIT
1	D4634-041	FWD, CENTER CEILING PANEL ASSEMBLY
1	D4634-141	* FWD, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-043	MIDDLE, CENTER CEILING PANEL ASSEMBLY
1	D4634-143	* MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-045	AFT, CENTER CEILING PANEL ASSEMBLY
1	D4634-145	* AFT, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-041	LH, FWD CEILING PANEL ASSEMBLY
1	D4635-141	* LH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-042	RH, FWD CEILING PANEL ASSEMBLY
1	D4635-142	* RH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-043	LH, AFT CEILING PANEL ASSEMBLY
1	D4635-143	* LH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-044	RH, AFT CEILING PANEL ASSEMBLY
1	D4635-144	* RH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
16	D4636-043	RECEPTACLE BRACKET ASSEMBLY
10	D4636-11	BRACKET
16	D4636-5	BRACKET
4	D4636-7	RETAINER PLATE
1	D4636-9	TEMPLATE
1	D4648-1	TEMPLATE
16	D4653-041	VENT MANIFOLD ASSEMBLY
6	D4653-11	CLAMP
3	D4664-7	SPACER
2	D4712-043	BRACKET ASSEMBLY
2	D4716-1	DUCT HOSE
4	D4716-3	DUCT HOSE
6	D4716-5	DUCT HOSE
1	D4728-057	HARNESS ASSEMBLY
1	D4728-063	HARNESS ASSEMBLY
24	D4730-020-035	VELCRO STRIP
16	D5032-1	DOUBLER
16	D5032-3	DOUBLER
16	2351-20-21-C3C	DZUS SCREW
16	50-009-2	GROMMET
10	AN970-3	WASHER
24	BT1.5I-M	TIE WRAP
12	BT3UH-L	TIE WRAP
1	CB 200	3.5g ACRYLIC ADHESIVE
2	CS125-1032-8-AA-CR	STUD (or CS125-1032-8-AA-CRM)
35	MS21042L3	NUT
36	MS24694-S51	SCREW
21	MS27039-1-15	SCREW
5	NAS1149D0316J	WASHER (or AN960JD10L)
34	NAS1149D0332J	WASHER (or AN960JD10)
6	NAS1149D0663J	WASHER (or AN960JD616)

NOTES: (*) DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE
D4634-141/-143/-145 ARE REPLACEMENT PANELS
D4635-141/-142/-143/-144 ARE REPLACEMENT PANELS

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Revision: D
Date: 13.12.16

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54
REF. FAA STC: SR03251NY
REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accommodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.




QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB-200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

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MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
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